



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

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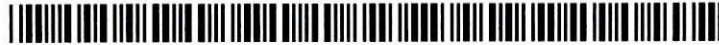
D206-667-147TRN
Job Sheet 168214-E



Part No: D206-667-147TRN

Job Qty: 1 ea

Part Name: Crosstube Assembly, Mid Fwd



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/30/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A IPP rev:A 11.01.06 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/29/17	11/29/17	0.00	0.00	Start Up Crosstubes		PMP
100	Mori Seiki	1 pcs	11/29/17	11/29/17	3.21	1.47	Mori Seiki TL-40		PMP
110	QC	1 pcs	11/29/17	11/29/17	0.00	0.00	QC2		PMP
120	Mori Seiki	1 pcs	11/29/17	11/29/17	0.00	1.47	Mori Seiki TL-40		PMP
130	QC	1 pcs	11/29/17	11/29/17	0.00	0.00	QC2		DAS PMP
140	QC	1 pcs	11/29/17	11/29/17	0.00	0.00	QC8		47 17-12-18
145	Crosstubes	1 pcs	11/29/17	11/29/17	0.00	0.25	Crosstube		9-89 2018/01/16 JSL
150	HandFXtube	1 pcs	11/30/17	11/30/17	0.00	0.13	Crosstube		GP
160	QC	1 pcs	11/30/17	11/30/17	0.00	0.00	QC7		
170	Packaging	1 pcs	11/30/17	11/30/17	0.00	0.00	Packaging3		
180	QC21-SA	1 Ea	11/30/17	11/30/17	0.00	0.00	QC21		

Part Op 100 - 1-Fill tube with sand & install plugs 206-147 on both ends as per Folio FB029 2-Turn first side as per Folio FB029
Descriptions: 3-Blend transition lines only with belt sander 60 grit.

120 - 1-Turn second side as per Folio FB029 2-Blend transition lines only with belt sander 60 grit.

145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.

150 - 1- handfinish X-TUBE INSIDE AND OUT

170 - LOCATION : LG014

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6002-115	1	88	0	0

B107867

Part Specifications

Specifications could not be found.

Plex 11/13/17 12:43 PM dart.poulin.mario

DART
AEROSPACE
S011930



Crosstube Assembly, Mid Fwd

PART NO:
Revision:
Operation:
Change No:

D206 – 667 – 147TRN

Start up Operation

Mfg Date: 11/21/17

Job No: 168214 – E

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632 – 5200
Email: sales@dartaero.com
www.dartaerospace.com

94

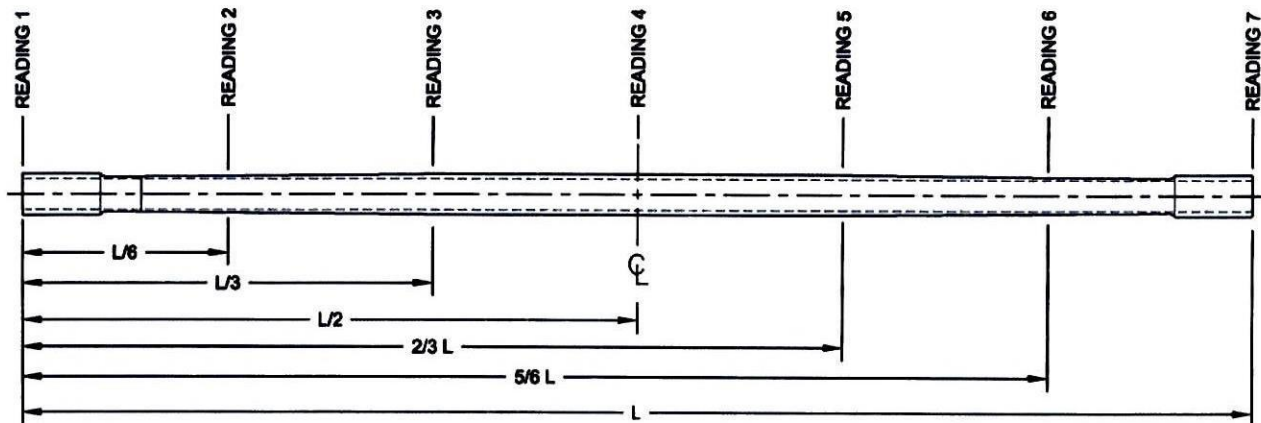
DART AEROSPACE LTD	Work Order:	168214-E
Description: Crosstube Assembly, Mid Fwd	Part Number:	D206-667-147
Inspection Dwg: D206-667-147 Rev: A		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.241	✓		VERN 08	
	1.984	+0.005/-0.000	2.187	✓			
	2.019	+0.005/-0.000	2.0235	✓			
	2.058	+0.005/-0.000	2.062	✓			
	2.097	+0.005/-0.000	2.101	✓			
	2.136	+0.005/-0.000	2.139	✓			
	2.176	+0.005/-0.000	2.1775	✓			
	0.125	+/-0.010	.125	✓		VERN 08	
	R0.063	+/-0.010	.063	✓		RC	
	R2.00	+/-0.010	2.0	✓		RC	
	R0.063	+/-0.010	.063	✓		RC	
	4.438	+/-0.030	4.430	✓		VERN 08	
SIDE B	2.240	+0.005/-0.000	2.241	✓		VERN 08	
	1.984	+0.005/-0.000	1.986	✓			
	2.019	+0.005/-0.000	2.022	✓			
	2.058	+0.005/-0.000	2.062	✓			
	2.097	+0.005/-0.000	2.101	✓			
	2.136	+0.005/-0.000	2.139	✓			
	2.176	+0.005/-0.000	2.1775	✓			
	0.125	+/-0.010	.125	✓		VERN 08	
	R0.063	+/-0.010	.063	✓		RC	
	R2.00	+/-0.010	2.0	✓		RC	
	R0.063	+/-0.010	.063	✓		RC	
	4.438	+/-0.030	4.432	✓		VERN 08	
	99.84	+/-0.020	99.84	✓		TAPE	

DART AEROSPACE LTD	Work Order:	
Description: Crosstube Assembly, Mid Fwd	Part Number:	D206-667-147
Inspection Dwg: D206-667-147 Rev: A		Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L = 0"	244	258	253	243	.015	0.035"
READING 2 L = 16.64	170	170	168	172	.004	
READING 3 L = 33.28	248	255	247	243	.012	
READING 4 L = 49.92	253	262	251	248	.014	
READING 5 L = 66.56	250	262	246	239	.023	
READING 6 L = 83.2	172	183	165	158	.025	
READING 7 L = 99.84	250	259	248	246	.013	

Calibration Result

Actual Block Thickness: 100 - 200

Sitescan 250 Measured Thickness: 100 - 200

Measured by: <u>PMP</u>	Audited by: <u>DAS 47 9-89</u>	Preliminary Approval:
Date: <u>2017-11-20</u>	Date: <u>17-12-28</u>	Date:

Rev	Date	Change	Revised by	Approved
B	11.06.21	New Issue	KJ	
C	12.06.04	Wall thickness form added	KJ	